

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009941**Date Inspected:** 24-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BK001

SMAW repair welding on weld joint 021 located on BK-001-017.

Welder is identified as Mr. Li Wenguo (066261). ZPMC QC is identified as Wu Zhi Cheng.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1. Noted CWI informed this QA Inspector CWR is pending approval by the engineer.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1AW

1. In progress of MT on panel point 8.5 deck plate diaphragm to floor beam flange weld joint looking east.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Steel backing used for buildup of edge was being removed by ZPMC worker on the longitudinal diaphragm at panel point 32 the bike path side of segment 5BE.

2. Lift 6AE and 6BE segments was moved in to Trail Assembly line (behind 5CE).

3. UT reject excavation on bottom plate 2AW+2BW weld joint (OBW2A-004). Y location is located at 2460mm from cross beam and length of excavation is approximately 110mm in length. CWR 869 was used at this weld joint.

4. UT reject excavation was performed at OBW5A-002 side plate (internal) weld joint on segment 5W counter weight side. Y locations (pulled from bottom plate), and lengths area as followed:

Y location is at 1090mm and is approximately 105mm in length.

Y location is at 1540mm and is approximately 111mm in length.

Y location is at 2800mm and is approximately 235mm in length.

Y location is at 3190mm and is approximately 95mm in length.

5. UT reject excavation was performed at OBW5A-002 side plate (external) weld joint on segment 5W counter weight side. Y locations (pulled from bottom plate) and lengths area as followed:

Y location 420mm and is approximately 105mm in length.

Y location 4900mm and is approximately 140mm in length.

6. UT reject excavation was performed at OBW5A-003 bottom plate (external) weld joint on segment 5W.

Y locations (pulled from bottom plate) and lengths area as followed:

Y location 8220mm and is approximately 160mm in length.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
